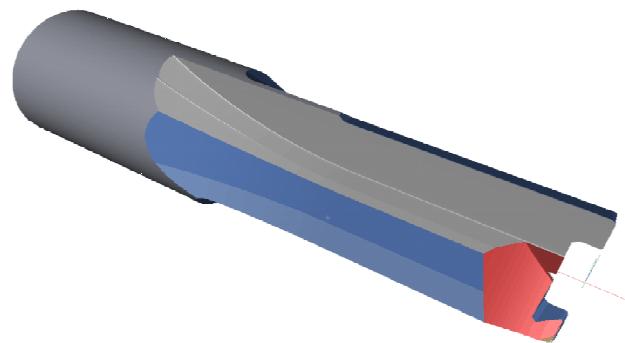


Face Profiled Endmill Ø11.5 Ø20.5

A02-001

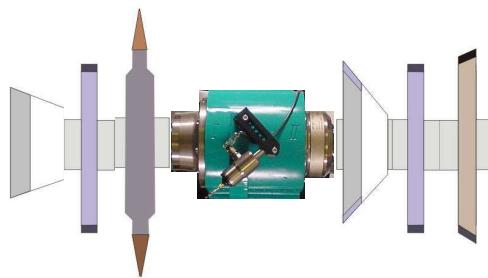
1. Cycletime for Production

Workpiece: Blank Ø22 Material CARBIDE												
Operations												
Probe	2000	25	35	40	60	35	30	35	50	30	45	10
Feed [mm/Min]		3	2	2	1	1	1	2	1	1	1	1
Power [kW]		19	19	19	22	22	22	22	22	22	22	22
Cutting speed [m/s]												
Used wheels		1	1	2	3	3	5	4	7	5	6	5
Grinding time [s]	12	359	277	84	16	202	273	196	46	257	171	264
Total cycle time	35 Min 57											

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	1A1 Ø125 D64
4	11V9 Ø100 D64
5	1V1 Ø125 D64
6	14EE1 Ø200 D76V20°



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2 1 5

3. Machine and Software Requirements

Machines:	5 axes CNC grinders : GEMINI DMR	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 31iA5	Software:	Quinto 5
Accessories:	AWL 8		

Responsible engineer: OP. 16.11.12

www.schneeberger.ch

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